

Work Order ID 80617

\*80617\*

Page 1

Friday, February 24, 2012 12:43:17 PM

Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date: 2-22-12 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3274

D

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80617**

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Item ID: D206-642-541

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: MI20104

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.  
Drill 3/16" pilot holes as per Dwg D32748-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe  
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP

12-3-15

1

CF 12-3-15

BE 12-03-15

DE

12/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Item ID: D206-642-541

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114 <b>*114*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	<i>P 12.03.20</i>						
116 <b>*116*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00	<i>P 12.03.20</i>			<i>1x</i>	<i>0</i>		
120 <b>*120*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	<i>HG 12-3-20</i>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Item ID: D206-642-541

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**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>11/12/07/13</u>								
	Sikaflex expire date: <u>12-8-13</u>								
	Start: <u>12:32</u> Time: <u>12:55</u>								
	Finish: <u>12-04-11</u> Time: <u>10:00</u>								
	(Adhere for 12 hours)								

① SAD 12-03-21

BB 12/03/21

BB/12/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item ID: D206-642-541

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12-3-29

170

Skidtubes

0.00

**\*170\***

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

SAD 12-03-29

SAD 12-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 80617

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Item ID: D206-642-541

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>		3.1"				1	0		BE 12/04/11
QC	Memo	0.00							
Quality Control									
190		0.00							
<b>*190*</b>	Skidtubes					1	0		BE 12/04/11
Skidtubes	Memo	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>m120164</u>								
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								

**CC 12/04/16**

**PTO →**

Dart Aerospace Ltd

W/O: 80617		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #:          Fault Category: Landing gear / skid the NCR: Yes No DQA:    Date: 12/05/04  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed:    Date: 12/5/7

NCR: 12-1392		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/11	190-4	9th hole from Aft has the counter bore @ 0.340" Should be @ 0.313" D.C. Tool:	UP 12/04/11 DS/04/12	Drill out + lat spacer Be weld in D-2645 B79564 A/R M12064 Reassembled	12-4-12 12/04/13	12/04/17	UP 12/04/11 DS/04/12	S 12/04/11
			UP 12/04/11	Grind weld flange + re counter bore as per 122 Dwg.	CF 12-4-16 12/04/17	12/04/17	UP 12/04/11	S 12/04/11

NOTE: Date & initial all entries

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**\*NS1\***

Stop \*NS2\*

**\*1\***

**\* 1 \***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

· 200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

## Memo

0.00

## Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

**\*210\***

QC

## Memo

0.00

### Quality Control

220

Pressure Wash per QSI005 4.3

0.00

**\*220\***

HandFinish

## Memo

0.00

## Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80617

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Item ID: D206-642-541 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 2/24/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 3/6/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 <b>*230*</b> Powdercoat Powder Coating  MI 21134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 8:15 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:45	0.00 0.00				1X	0		M/A 12/04/18
240 <b>*240*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				1X	0		12/04/18
250 <b>*250*</b> HandFinish Hand Finishing	HandFinishing  Memo 1-Install Nut Plate as per Dwg D3274. Appiy LPS-3 to Nut Plate and rivets. A/RN/ALPS-3 114596 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 121221 Sikaflex expire date: 13/01	0.00 0.00				1	0	DP	12/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**Work Order ID 80617**

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Item ID: D206-642-541

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260

QC5- Inspect part completeness to step on W/O

0.00

**\*260\***

QC

Memo

0.00

Sizler

Quality Control

Inspect Nut Plate &amp; Inserts

270

HAND FINISHING RESOURCE #1

0.00

**\*270\***

HandFinish

Memo

0.00

1 &amp; (2P) 12/07/18.

Hand Finishing

1-Install wearpads &amp; gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 121 221Sikaflex expire date: 13/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 121 221Sikaflex expire date: 13/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 2/24/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC5- Inspect part completeness to step on W/O

0.00

**\*280\***

QC

Memo

0.00

Quality Control

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*290\***

Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

**\*300\***

QC

Memo

0.00

Quality Control

MC 12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80617

**\*80617\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

Manufactured No

110

Each

121.0000

1

1

**\*D2600-1-190\***

Extrusion Round 3" 206

\*\*

*DP 12-3-15*

### Location

### Loc Qty

### Loc Code

HALL

45

69622

45

LG

76

76912

76

D3285-1

Manufactured No

110

Each

64.0000

1

**\*D3285-1\***

Cap

\*\*

*①*

*BE 12/03/15*

### Location

### Loc Qty

### Loc Code

LG002

64

52511

17

52647

47

D3282-041

Manufactured No

150

Each

12.0000

1

**\*D3282-041\***

Float Web (206L/407)

\*\*

### Location

### Loc Qty

### Loc Code

LG

12

74294

3

77498

9

*77498*

*1*

*DP 12-3-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 24, 2012 12:43:23 PM

Work Order ID: 80617

**\*80617\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

1,428.000

12

12

**\*D2649\***

Cross Bolt Spacer

\*\*

LocationLoc QtyLoc Code

LG

1301

77574

2

78019

104

79502

403

79503

400

79504

392

LG001

127

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

D3275-1

Manufactured No

190

Each

228.0000

12

12

**\*D3275-1\***

Crossbolt Spacer

\*\*

LocationLoc QtyLoc Code

LG002

228

66930

106

73393

70

74437

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Friday, February 24, 2012 12:43:23 PM

Work Order ID: 80617

**\*80617\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,526.000

2

2

**\*CR3212-4-03\***

Cherry Rivet

\*\*

2

*DP 12/04/18*

Location

Loc Qty

Loc Code

FP002

536

114859 ✓

536

ST331

990

110139

2

119017

988

D3415-041

Manufactured

No

250

Each

24.0000

1

1

**\*D3415-041\***

Nut Plate

\*\*

1

*DP 12/04/18*

Location

Loc Qty

Loc Code

ST042

24

67605 ✓

24

CCR264SS3-3

Purchased

No

250

Each

781.0000

2

2

**\*CCR264SS3-3\***

Cherry Rivet

\*\*

2

*DP 12/04/18*

Location

Loc Qty

Loc Code

ST331

781

113973

2

117849 ✓

129

119017

650

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 24, 2012 12:43:23 PM

Work Order ID: 80617

\*80617\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

3,453.000

78

78

\*\*

78

SP

12/04/18

\*AI S4-1032-130\*

Insert

Location

Loc Qty

Loc Code

ST280

1116

119084

116

120671

1000

ST281

2337

119632

3

120410

334

120807 ✓

2000

D3536-15

Manufactured

No

270

Each

18.0000

1

1

\*\*

1

SP

12/04/18

\*D3536-15\*

Gasket

Location

Loc Qty

Loc Code

FP002

18

73318

18

D3536-23

Manufactured

No

270

Each

20.0000

1

1

\*\*

1

SP

12/04/18

\*D3536-23\*

Gasket

Location

Loc Qty

Loc Code

FP002

20

43406

1

73312

7

74510

12

D3536-35

Manufactured

No

270

Each

11.0000

1

1

\*\*

1

SP

12/04/18

\*D3536-35\*

Gasket

Location

Loc Qty

Loc Code

FP002

11

74511

11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 24, 2012 12:43:23 PM

Page 5

Work Order ID: 80617

\*80617\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-39 Manufactured No

270 Each

20.0000

1 1

\*D3536-39\*

Gasket

\*\*

1 (2P) 12/04/18

Location

Loc Qty

Loc Code

FP002

20

73317 ✓

20

D3535-15 Manufactured No

270 Each

16.0000

1 1

\*D3535-15\*

Wearshoe

\*\*

1 (2P) 12/04/18

Location

Loc Qty

Loc Code

FP001

16

73315

4

74512 ✓

12

D3535-35 Manufactured No

270 Each

15.0000

1 1

\*D3535-35\*

Wearshoe

\*\*

1 (2P) 12/04/18

Location

Loc Qty

Loc Code

FP001

15

67598

1

70815

1

78873

13

D3535-39 Manufactured No

270 Each

26.0000

1 1

\*D3535-39\*

Wearshoe

\*\*

1 (2P) 12/04/18

Location

Loc Qty

Loc Code

FP001

26

69759

1

73316 ✓

13

74513

12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 24, 2012 12:43:23 PM

Work Order ID: 80617

\*80617\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-23 Manufactured No

270 Each

21.0000

1

1

\*D3535-23\*

Wearshoe

\*\*

1

(2P) 12/04/18

Location

Loc Qty

Loc Code

FP001

80330

21

73314

10

74508

11

D3537-3 Manufactured No

270 Each

22.0000

1

1

\*D3537-3\*

Wearpad

\*\*

1

(2P) 12/04/18

Location

Loc Qty

Loc Code

FP002

80338

22

74500

17

76986

5

D3537-1 Manufactured No

270 Each

27.0000

9

9

\*D3537-1\*

Wearpad

\*\*

9

(2P) 12/04/18

Location

Loc Qty

Loc Code

FP001

73716

22

78592

22

FP002

69817

5

5

AN960C10L ☒ NAS1149C0332 Purchased No

270 Each

0.0000

80

80

\*AN960C10I\*

washer

121255

\*\*

80

(2P) 12/04/18

AN960C416 ☒ NAS1149C0463 Purchased No

270 Each

0.0000

1

1

\*AN960C416\*

washer

117435

\*\*

1

(2P) 12/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 7

Friday, February 24, 2012 12:43:24 PM

Work Order ID: 80617

**\*80617\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270

Each

904.0000

2

2

**\*D3672-1\***

Phenolic Washer

\*\*

2

(2P)

12/04/18

Location

Loc Qty

Loc Code

FP001

268

66821

268

ST060

636

72229

136

76277 ✓

500

AN3C4A Purchased No

270

Each

3,715.000

80

80

**\*AN3C4A\***

BOLT

\*\*

80

(2P)

12/04/18

Location

Loc Qty

Loc Code

ST350

3715

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187 ✓

2000

120423

10

120521

964

120769

515

120799

181

AN4C5A Purchased No

270

Each

312.0000

1

1

**\*AN4C5A\***

BOLT

\*\*

1

(2P)

12/04/18

Location

Loc Qty

Loc Code

ST355

312

112243 ✓

212

119017

100

Friday, February 24, 2012 12:43:24 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

Friday, February 24, 2012 12:43:24 PM

Work Order ID: 80617

**\*80617\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 2/24/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

78.0000

1

1

**\*D2646\***

Aft Cap

\*\*

1

*SP 12/04/18*

Location

Loc Qty

Loc Code

FP002

*79562*

78

62678

5

68280

5

70945

1

71070

2

73294

1

73825

18

78018

46

D3413-1

Manufactured No

270

Each

104.0000

1

1

**\*D3413-1\***

Ring

\*\*

1

*SP 12/04/18*

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

ST464

83

75478

12

76754

43

77940

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3274</b>	REV. <b>15</b> SHEET <b>1</b> OF <b>4</b>
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b> SCALE <b>NTS</b>	
<b>A</b>	<b>04.03.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>04.08.09</b>	<b>MOVE SADDLE HOLE: 42.14 WAS 42.76</b>	
<b>C</b>	<b>05.03.16</b>	<b>ADD -043; NEW INSERTS</b>	
<b>D</b>	<b>06.12.19</b>	<b>NEW INSERTS, SS WEARSHOE + GASKET</b>	

NO. **80617**

**RELEASED** **12/24**

**07.02.12**

**DEO ATTACHED**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3282-041  
FLOAT WEB

Ø0.313  
(TYP, 12 PLACES PER SIDE)

2.500

2.500

17.26

35.07

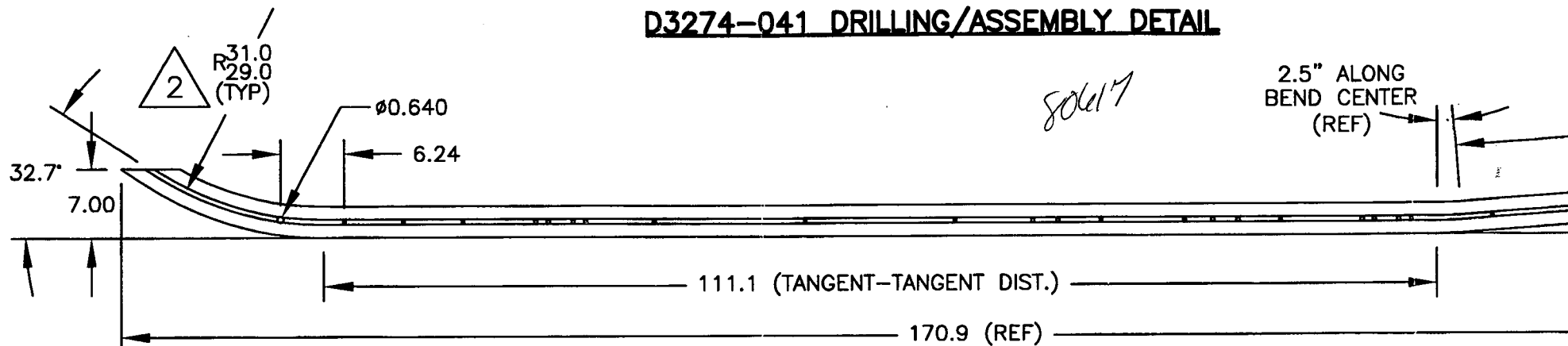
45.33

82.250

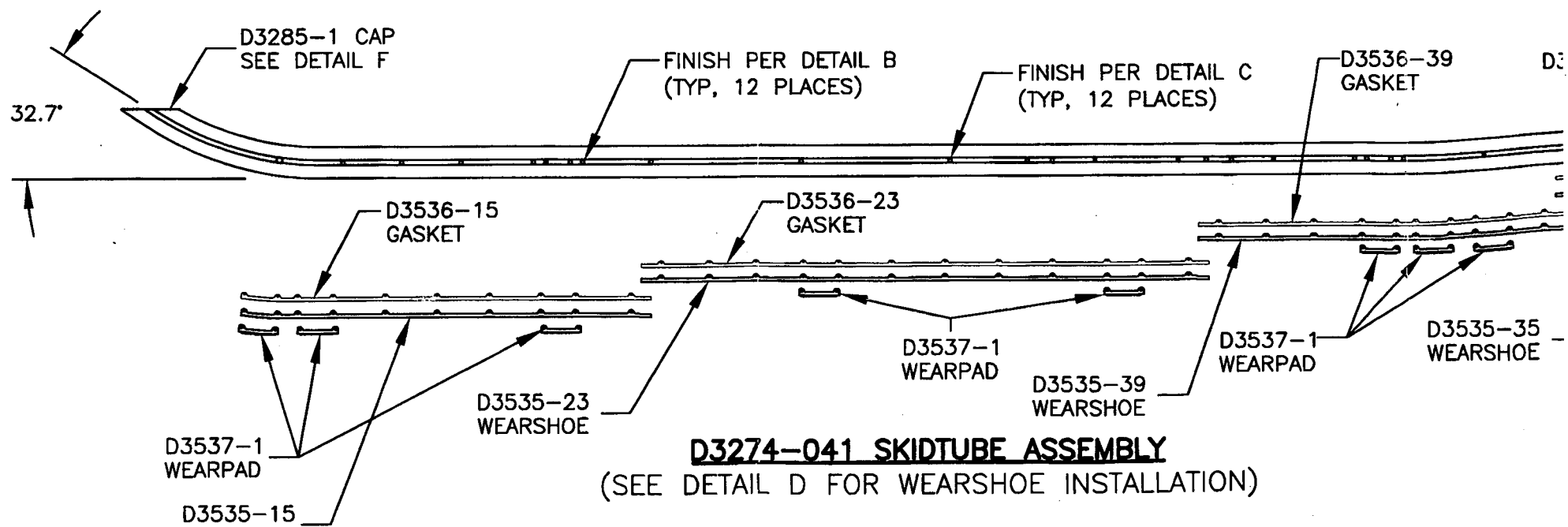
94.57

190 (REF)

### D3274-041 DRILLING/ASSEMBLY DETAIL



### D3274-041 BEND/DRILLING DETAIL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3282-041  
FLOAT WEB

ø0.313  
(TYP, 37 PLACES PER SIDE)

2.500

2.500

35.07

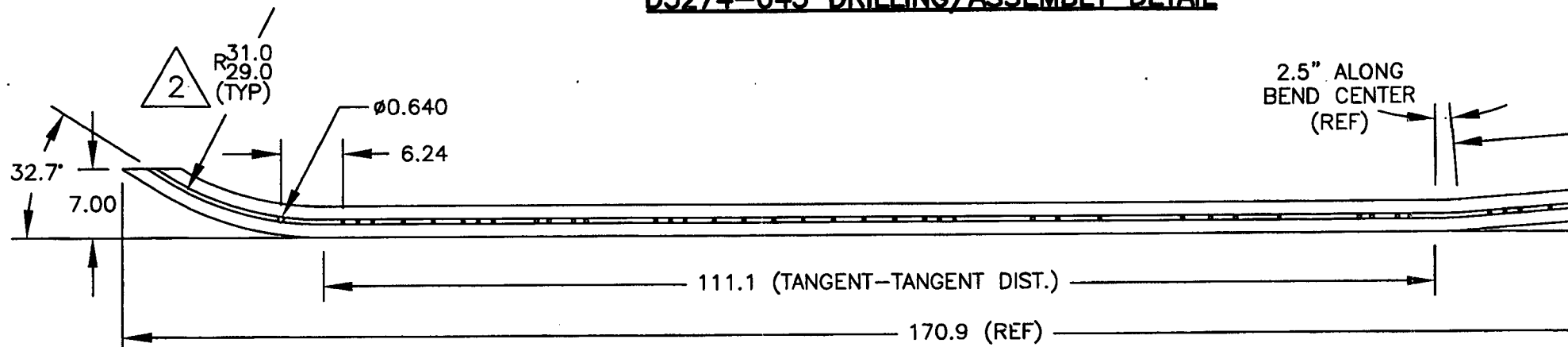
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82.250

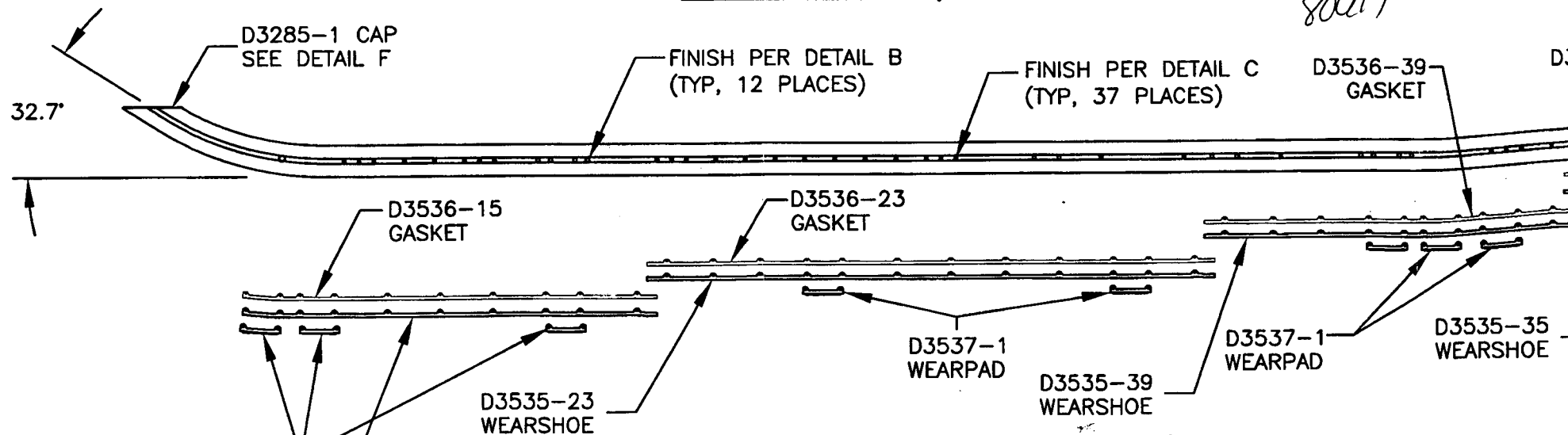
91.57

190 (REF)

### D3274-043 DRILLING/ASSEMBLY DETAIL



### D3274-043 BEND/DRILLING DETAIL



### D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

D3537-1  
WEARPAD

D3535-15

D3536-15  
GASKET

D3535-23  
WEARSHOE

D3536-23  
GASKET

D3537-1  
WEARPAD

D3535-39  
WEARSHOE

D3537-1  
WEARPAD

D3535-35  
WEARSHOE

D3536-39  
GASKET

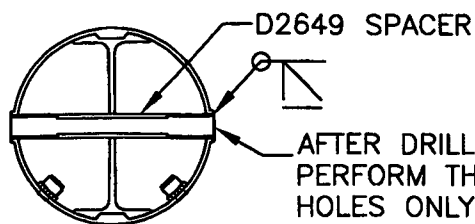
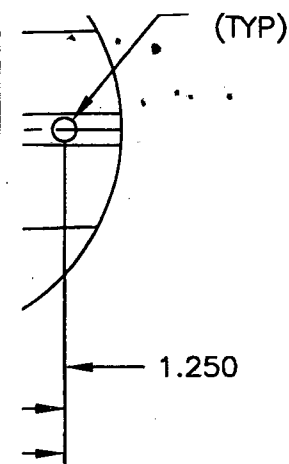
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

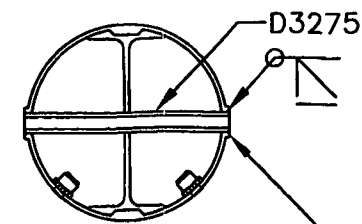
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.375$   
HOLES ONLY:

1. CHAMFER HOLE  $0.030 \times 45^\circ$
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO  $\phi 0.313 \times 0.75$  DEEP



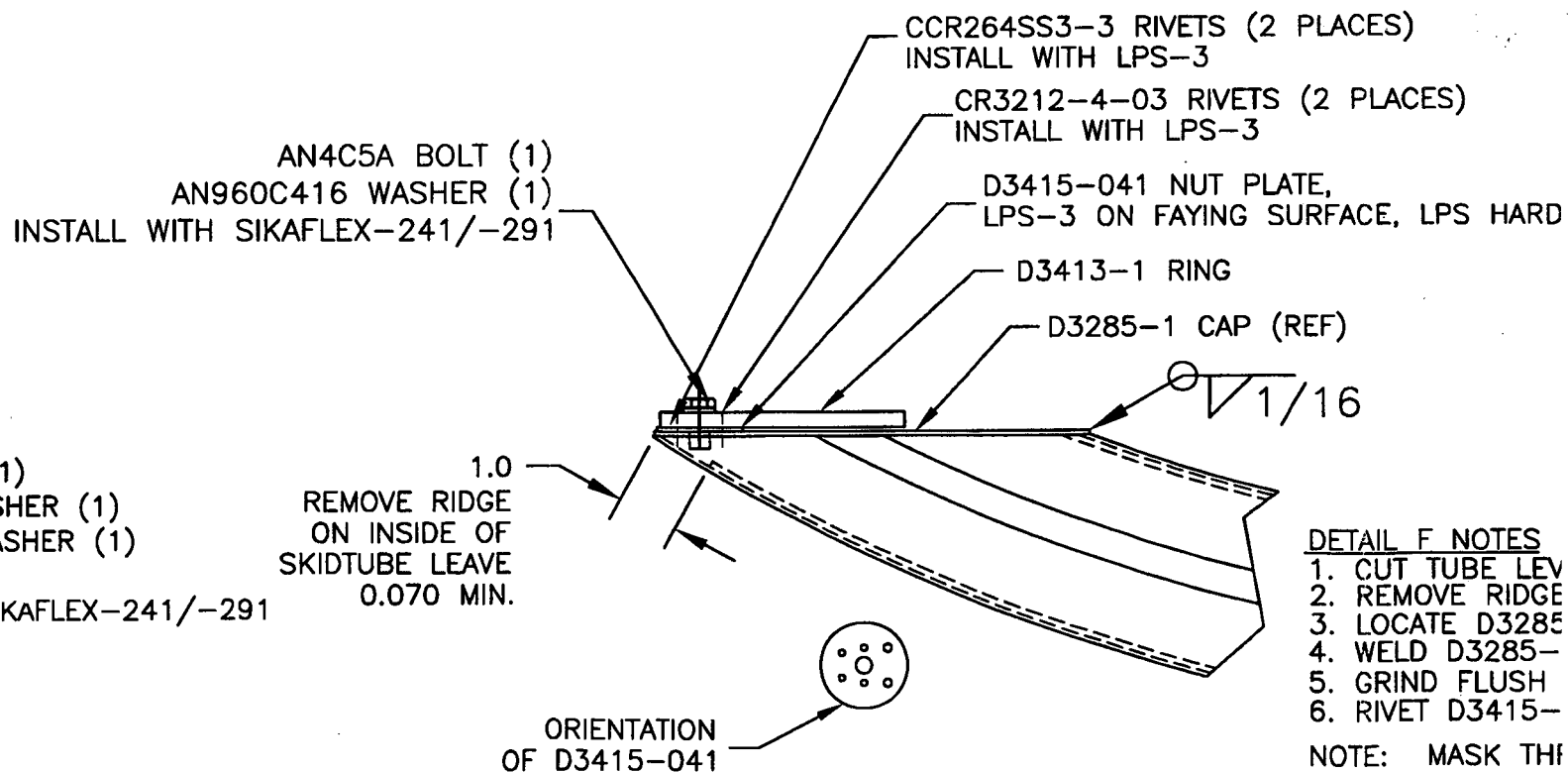
## DETAIL D

S7-1032-130 INSERT (1)  
J3C4A BOLT (1)  
J960C10L WASHER (1)  
8 PLACES)  
SKET/WEARSHOE/WEARPAD (REF)

## DETAIL E

AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

## DETAIL F: END FINISHING DETAIL



DETAIL F NOTES  
1. CUT TUBE LEV  
2. REMOVE RIDGE  
3. LOCATE D3285  
4. WELD D3285-  
5. GRIND FLUSH  
6. RIVET D3415-

NOTE: MASK THE  
PRIOR TO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

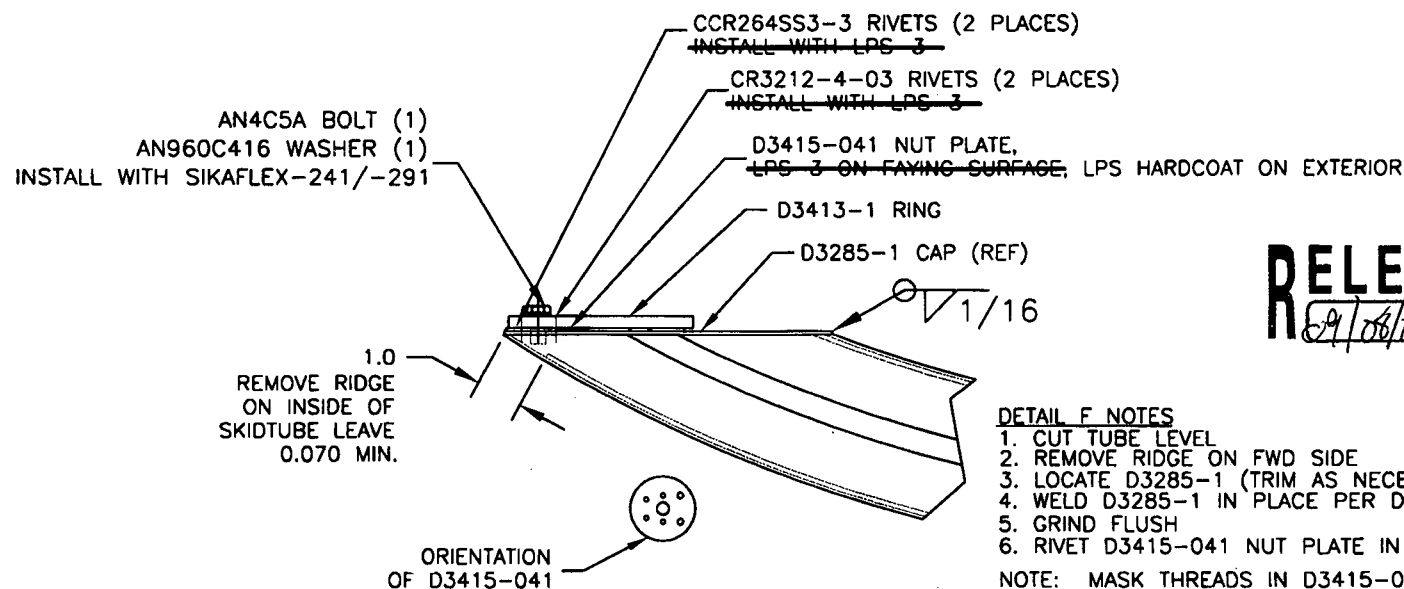
DRAWING NO. D3274...	TITLE SKIDTUBE ASSEMBLY	REV. D	<b>DART AEROSPACE USA, INC</b>	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>M</i>	APPROVED <i>WAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 287

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 79657  
Part number: A206-646-341  
Description: Skid tube  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Alum  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

UNACCEPTABLE

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier David Smith Date of Test Coupon 12-04-03  
Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld